



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.0116

Job Sheet 170553



Part No: 647.0116

Job Qty: 20 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 1/31/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV A1 SHEET 6 IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		1/30/18	0.00	0.00	Start Up Waterjet		OK 18/02/18
110	Waterjet	20 pcs		1/31/18	0.00	1.07	Waterjet1		OK 18/02/18
120	QC	20 pcs		1/31/18	0.00	0.00	QC2 Waterjet-1		OK 18/02/18
130	QC	20 pcs		1/31/18	0.00	0.00	QC8-1		OK
140	Outsource	20 pcs		1/31/18			ATG001-VC		
150	Packaging	20 pcs		1/31/18	0.00	0.00	Packaging2		DAS
160	QC	20 pcs		1/31/18	0.00	0.00	QC5		38
190	Packaging	20 pcs		1/31/18	0.00	0.00	Packaging3-1		3.88
200	QC21-SA	20 Ea		1/31/18	0.00	0.00	QC21		21

Part Op 110 - 1-Cut as per Dwg

Descriptions: 140 - Issue P/O 038709 ATG, black anodize and prime as per dwg 647.0116 Rev. A

190 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

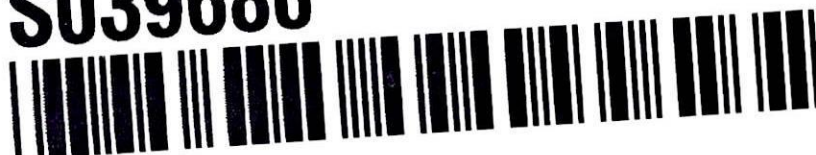
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.032	2024-T3 .032 Sheet	1.1260 sf (.0563 ea)	90-Start up Operation	

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.100Inches + 0.004 - 0.001	0.104 0.099	Diameter	
2	Doubler	0.177Inches + 0.005 - 0.001	0.182 0.176	Diameter	
3	Doubler	1.200Inches ± 0.010	1.210 1.190		
4	Doubler	0.900Inches ± 0.010	0.910 0.890		
5	Doubler	1.500Inches ± 0.010	1.510 1.490		
6	Doubler	1.100Inches ± 0.010	1.110 1.090		
7	Doubler	1.200Inches ± 0.010	1.210 1.190		
8	Doubler	1.500Inches ± 0.010	1.510		

DART
AEROSPACE
S039680



Doubler

PART NO: 647.0116
Original Serial #: S039680
Revision:
Operation:
Change No:

Start up Operation

02/06/18
Job No: 170553

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

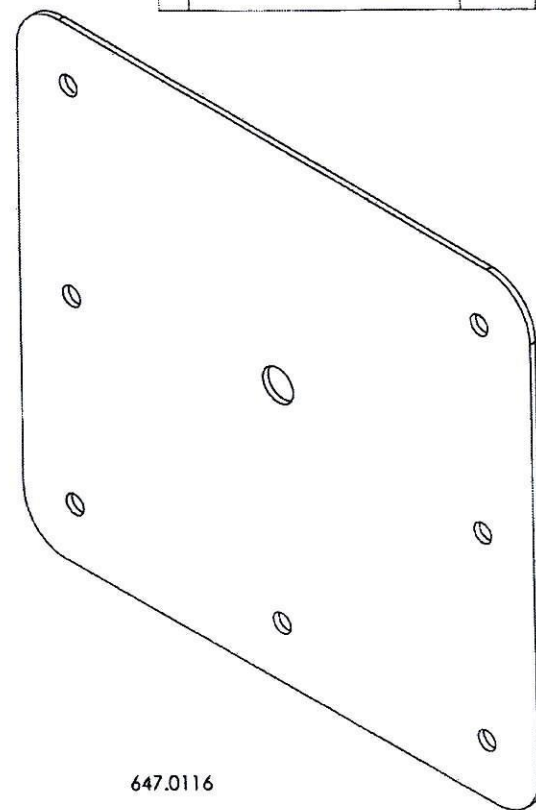
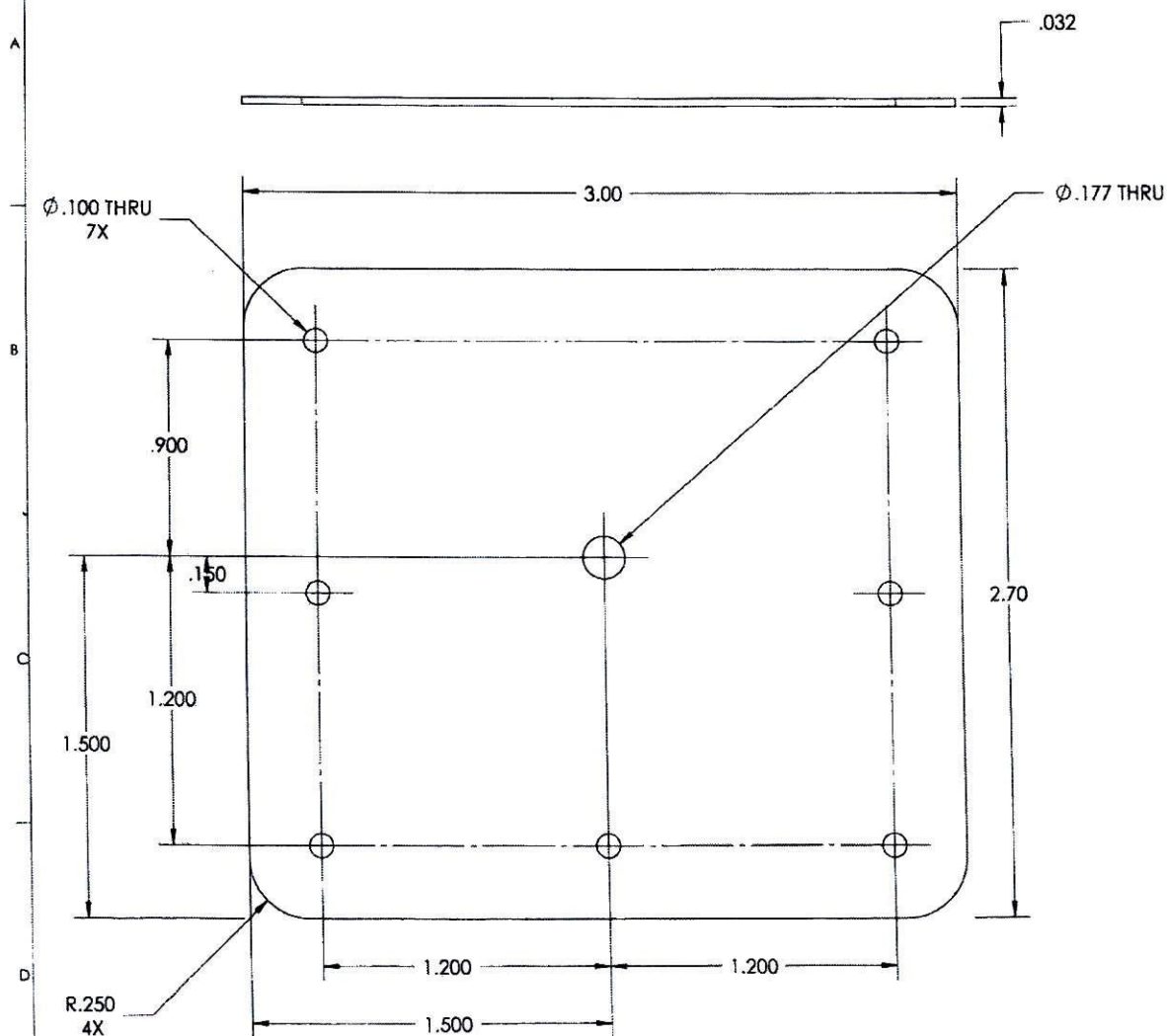
			1.490
9	Doubler	2.700Inches ± 0.030	2.730 2.670
10	Doubler	3.000Inches ± 0.030	3.030 2.970

Plex 1/17/18 10:45 AM dart.poulin.mario

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20k

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



647.0116

ORIGINAL DATE: 03-28-09		APICAL INDUSTRIES	
DRAWN BY: DIRECTOR		2608 TEMPLE HEIGHTS DR.	
P. EDWARDS		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL: P. BRAVO		SHEETMETAL	
P. BRAVO			
CONTRACT NO:			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		SHEET: 07M26	DWG NO: 647.0100
TOLERANCES ARE: 1 PLACE DECIMALS $\pm .01$		SCALE: NONE	REV: A
3 PLACE DECIMALS $\pm .003$			
ANGLES: 1°			

SHEET 5 OF 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038709

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038709
PO Date: 2/12/18
Due Date: 2/23/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
FEB 13 2018

Items				Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Line Item	Job	Part	Description							
1	169382	647.2114	Upper U Channel Issue P/O to ATG : _____ 1- Anodize as per MPP-172 sect. 2.1 2- Pretreatment as per MPP-172 sect. 3.3 3-Prime as per MPP-172 sect. 4.3 As Per Dwg 647.2100 Rev. E	Firmed	3/2/18	10 pcs	0 pcs 2x	10 pcs AT 18/02/22	\$13.52/pcs	\$135.20
2	169389	647.7821	Eye Bolt Fitting LH Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 647.7800 Rev. A 2- PRIME AS PER DWG 648.7800 Rev. A	Firmed	3/2/18	15 pcs	0 pcs	15 pcs	\$11.32/pcs	\$169.80
3	169518	RBW109-3101-58-2-7	Handle -Issue P/O to ATG : _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant As Per Dwg RBW109-3101-58-2-7 Rev. 3	Firmed	2/21/18	1 pcs	0 pcs 1x	1 pcs AT 18/02/22	\$20.12/pcs	\$20.12
4	170458	646.3313	Upper Guide Issue P/O to ATG : _____ Hard Anodize Color Black and Prime as per DWG 646.3300	Firmed	3/2/18	9 pcs	0 pcs	9 pcs	\$15.37/pcs	\$138.33
5	170538	RBE350A93-3205-00E	Engine G/B Input Flange Holding Wrench -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A93-3205-00E Rev. 2A	Firmed	2/21/18	6 pcs	0 pcs 6x	6 pcs AT 18/02/22	\$11.65/pcs	\$69.90
6	170553	647.0116		Firmed	3/2/18	20 pcs	0 pcs 20x	20 pcs AT 18/03/21	\$9.67/pcs	\$193.40

Plex 2/13/18 1:45 PM dart.baker.diane

DAS
38
9-89
DAS
11
9-89



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914685

Date: 28-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
8 ea	Part: 647.2114 Upper U Channel Anodize as per MPP-172 sect. 2.1 2 -Pretreatment as per MPP-172 sect 3.3 3-Prime as per MPP-172 sect 4.3 Job: 22527	Rev: E PO: PO038709 Line: 1	
15 ea	Part: 647.7821 Eye Bolt Fitting LH Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - 2 mils) per drawing. Job: 22528	Rev: A PO: PO038709 Line: 2	
9 ea	Part: 646 3313 Upper Guide Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22530	Rev: A PO: PO038709 Line: 4	
20 ea	Part: 647.0116 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22532	Rev: B PO: PO038709 Line: 6	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: 28/2/18 Certified Signature: Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914685

Date: 28-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		OUR TRUCK
Quantity	Description	
	Receiver Signature: _____	
	A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
	Made in Canada.	